

Date: Monday, 23/03/2009 9:51:30 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP (CASTING DETAIL)  
 Job Number : 46661  
 Estimate Number : 10510  
 P.O. Number :  
 This Issue : 23/03/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : MACHINED PARTS  
 Previous Run : 43504  
 Part Number : D25763  
 Drawing Number : D2576 REV G  
 Project Number : N/A  
 Drawing Revision : G  
 Material :  
 Due Date : 30/03/2009 Qty: 105 Um: Each  
 Written By : JLM 09.03.23  
 Checked & Approved By :  
 Comment : Est: E 02.08.19 Consolidated D2576-1 and D2576-3 KJ/RF

Est Rev:D As per Rev G 07-09-05 JLM Verified By:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25761 Step (casting detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 105.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
1	D2576-1	Step (Casting Detail)	45553

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS1

1- Machine as per Folio FA332 and Dwg D2576

2- Deburr

JLP 09/03/25 / J.F. 09/03/27 (103)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLP 09/03/25 / J.F. 09/03/27 (103)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JLP 09/03/27 (103)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Barilley

JLP 09/03/30 (105)

Date: Monday, 23/03/2009 9:51:31 AM  
User: Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP (CASTING DETAIL)

Job Number: 46661

Part Number: D25763

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/01 *MF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF*  
09-03-31

# Dart Aerospace Ltd

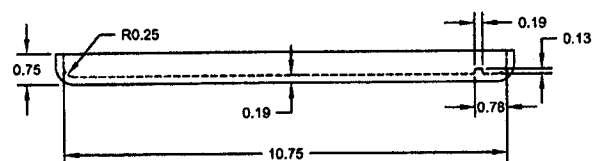
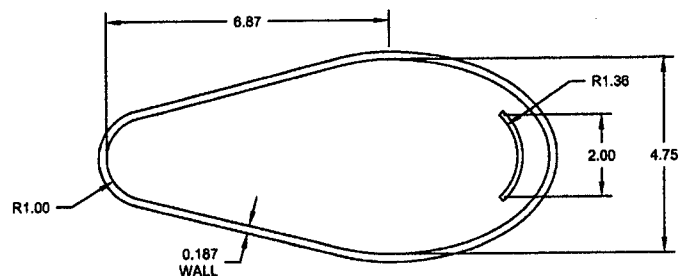
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2576-3 PAR #: N/A Fault Category: Prod/Machined parts NCR: Yes No DQA: D Date: 05/04/03  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 05/04/03

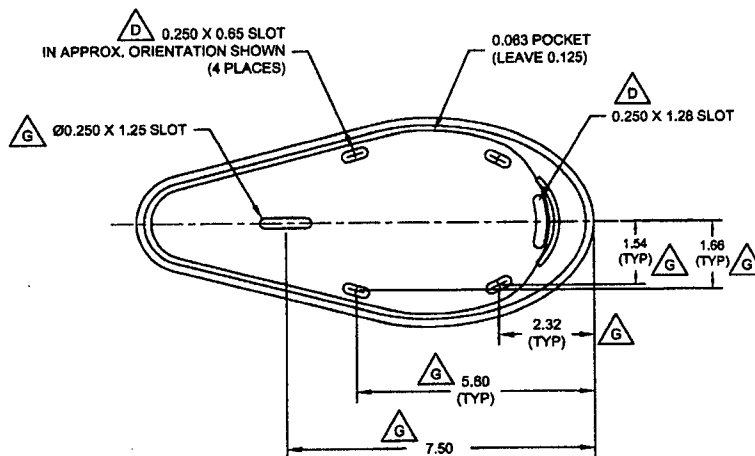
NCR: <u>46661</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/27	2.0	Part thickness (Dim. .125") is too thin. Part lift in the Jaws during machining. 2 parts are scrap.	UP 09.03.27 per QSI 012	Scrap parts. No replace.	I.F. 04/03/27	88 09/03/28	UP 09.03.27 per QSI 012	09.03.27
		R.C. process.						

NOTE: Date & initial all entries





**D2576-1 CASTING**



**D2576-3 MACHINING DETAIL**  
(MAKE FROM D2576-1)

**NOTES:**

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

w/o 46661

**RELEASED**

07.08.21

REV.	DESCRIPTION	BY	DATE
G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1089)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.08.15		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. G  
D2576 SHEET 1 OF 1  
TITLE SCALE  
STEP 1:3

COPYRIGHT © 1996 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.